Monday, 8/21/2006 2:11:05 PM

User

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**

: 28248 : 10897

P.O. Number

:NA

: 8/21/2006 This Issue

Prsht Rev. First Issue

: NIA

: 27144

S.O. No. : N/A

Type

: MACHINED PARTS

Previous Run Written By

Checked & Approved By

Comment

: Est Rev:F

Drawing Name

: BUSHING

Part Number

: D2618

Drawing Number

. D2618 REV B1

Project Number **Drawing Revision**

Material

Due Date

: N/A : B1

: N/A

: 9/8/2006

Qty:

200 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

Delrin Round Bar .50"

MDELRINR0500



JLM

Comment: Qty.:

0.2709 f(s)/Unit Total:

54.1800 f(s)

Delrin Round Bar .50" black (MDELRINR0500)

M100724 X30'

06/09/09

2.0



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA195 & Dwg D2618.

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2-Deburr

INSPECT PARTS AS THEY COME OFF MACHINE

06109109 201

3.0

QC2

5,6

36

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0 PACKAGING 1



PACKAGING RESOURCE #1

201

90

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

W/O:			WO	RK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
			WORK ORDE	D NON CONFORMANC)F (NOF			L	
NCR:			WORK ORDE	R NON-CONFORMANO	JE (NCR	()			
		Description of NC		Corrective Action Section B		Vorifi	cation	Ammental	Annroyal
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date		Verification Section C	Approval Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B	Verification	A	A		
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector	
				,					
					:				
			h					1	

Part No:	PAR #:	Fault Category:	NCR:	Yes No DQA:	Date: <u>&/ 09/</u> /2
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Date:

Monday, 8/21/2006 2:11:05 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 28248

.0240

Part Number: D2618

Job Number:



Seq. #:

Machine Or Operation:

Inspection Level 21

Description:

6.0

DC

DOCUMENT CONTROL



OCUMENT CONTROL

Comment: DOCUMENT CONTROL



201

Job Completion



Dowo9/12 U Olev 9/2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	P PROCEDURE CHANGE			Qty	Approval Mfg / Design Mgr	Approval QC Inspector			
					ļ					

NCR:		. •	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	,	Verification	Annroyal	Annroval			
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector			
				· gasanagas							
		:									

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				QA: N	I/C C	osed:	Date:

DART AEROSPACE LTD	Work Order:	28248
Description: Bushing	Part Number:	D2618
Inspection Dwg: D2618 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	001111101110
3.100	+/-0.010	3.105				
Ø0.500	+0.000/-0.010	0.500				
Ø0.313	+0.020/-0.000	0.318				
				. ,		

Measured by: 5.6	Audited by:	T3 G-	Prototype Approval:	N/A
Date: 06109/40	Date:	06-09.10	Date:	N/A

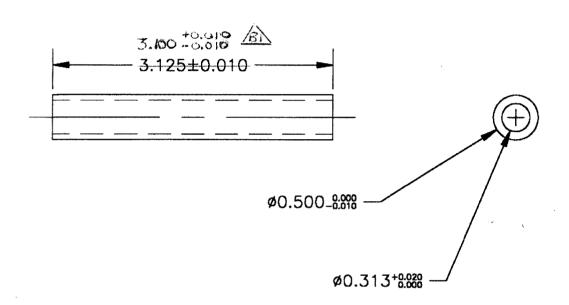
	Rev	Date	Change	Revised by	Approved
	Α	04.08.26	New Issue	KJ/JLM ,	1
	В	04.09.10	Changed tolerance for Ø0.500	KJ/JLM	Chl
_					7,0,7





DESIG	N	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		
CHEC	KĘD	APPROVED	DRAWING NO.	REV	. 8
\mathcal{B}	7	BW	D2618 SHEET	1 0	F 1
DATE			MLE	SC	ALE
 96:1	0:30		BUSHING		1:1
В		97.05.09	3.125 WAS 1.625, .313 WAS .375		
81	QH	04.06.03	CHANGE DIM FOR BETTER FIT		

RELEASED 91/05/13 DS



MATERIAL: DELRIN OR TEFLON OR NYLON

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER